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(54) Preparation of 1,1,1,3-tetrafluoropropene(1234ze)

(57) Disclosed is a process for the preparation of cis/trans 1,1,1,3-tetrafluoro-2-propene (1234 ze) which comprises (a) contacting 1,1,1,3,3-pentafluoropropane (245fa) with an alkaline solution, preferably an aqueous

or alcoholic solution of a base such as KOH, NaOH, Ca(OH)₂ or Mg(OH)₂, or with a chromium-based catalyst, such as fluorided Cr₂O₃ or fluorided Cr/Ni/Al₂O₃, and (b) recovering cis/trans 1,1,1,3-tetrafluoro-2-propene from the reaction mixture.

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Description

[0001] This invention relates to preparation of *cis/trans* 1,1,1,3-tetrafluoropropene ("1234ze"), a monomer useful for the preparation of various homopolymers and copolymers, particularly to processes for the dehydrofluorination of 1,1,1,3,3-pentafluoropropane ("245fa"), a known blowing agent, to 1234ze using a chromium-based catalyst or a strong base. While the prior art, R. N. Haszeldine, J. Chem. Soc., 1952 (3490), describes the synthesis of *cis/trans* 1,1,1,3-tetrafluoropropene by fluorination of 1,1,1-trifluoro-2-propyne, this latter feed stock material is not available commercially.

[0002] Herein provided is a process for the preparation of 1234ze which comprises

- (a) contacting 245fa with an alkaline solution or with a chromium-based catalyst, and
- (b) recovering *cis/trans* 1,1,1,3-tetrafluoro-2-propene from the resulting reaction mixture.

[0003] It has now been discovered that the *cis* and *trans* isomers of 1,1,1,3-tetrafluoro-2-propene (1234ze) can be conveniently prepared by dehydrofluorination of the blowing agent, 245fa, using either a strong base (either an aqueous or alcoholic solution) or a chromium-based catalyst.

[0004] The catalyzed process is preferably carried out in the gas phase. Use of an oxygen-containing gas such as air is desired to extend the catalyst lifetime, the level of oxygen generally being from about 1 to about 10 volume percent (preferably about 2 to 5%), based on the volume of the organic feed. Temperatures of from about 100°C. to about 600°C. are typically used, preferably from about 300°C. to about 400°C. The pressure can be atmospheric. Contact time (total flow rate per catalyst volume) is typically from about 1 to about 60 seconds, preferably from about 20 to 50 seconds. The catalyst is a chromium-based catalyst such as fluorided chromium oxide, Cr₂O₃, which chromium-based catalyst is either unsupported or supported on a support such as activated carbon, graphite, fluorided graphite or fluorided alumina, the chromium catalyst being used alone or in the presence of a co-catalyst selected from a nickel, cobalt, manganese or zinc salt. Two such preferred chromium catalysts are high surface area chromium oxide and chromuminickel on fluorided alumina (Cr/Ni/AlF₃), preparation of this latter catalyst being taught, for example, in European Patent 486333. The chromium-based catalysts are preferably activated before use, typically by a procedure wherein the catalyst bed is heated to about 370°-380°C. (normally with a continuous flow of nitrogen), after which a mixture of approximately equal volumes of HF and air or nitrogen (preferably nitrogen) are fed over the catalyst bed for about 18 hours.

[0005] The dehydrofluorination can also be accomplished using an alkaline solution of a strong base, such as an aqueous or alcoholic solution of potassium hy-

droxide (KOH), sodium hydroxide (NaOH), calcium hydroxide (Ca(OH)₂) or magnesium hydroxide (Mg(OH)₂). For the alcoholic solution, a conventional alcohol such as ethanol can be used. The solution typically is from about 0.01 to about 10 molar, preferably 0.1 to 5 molar. The dehydrofluorination is typically conducted at a temperature of from about 20°C. to about 100°C., preferably from about 20°C. to about 50°C.

[0006] The following examples are illustrative.

[0007] Example 1. 52.4 Grams of a high surface area Cr₂O₃ catalyst was activated by first feeding 30 ccm of nitrogen for 2 hours at 370°C. followed by ccofeeding 30 ccm of HF and 30 ccm of nitrogen for 18 hours at 370°C. Subsequently, a mixture of 20 ccm of 245fa and 3 ccm of air (equal to about 3 volume % of oxygen, based on the 245fa volume) was fed over the catalyst bed at 400°C for a contact time of 45 seconds. Conversion was 96.2%. Selectivity for the desired (1234ze) product was about 96.3% (about 18.5% *cis*, about 77.8% *trans*). Performance of the catalyst was steady for 360 hours.

[0008] Example 2. Example 1 was repeated using Cr/Ni/AlF₃ catalyst (activated at 370°C. using a cfeed of 30 ccm of nitrogen and 30 ccm of HF for 18 hours) in a series of 3 tests, using the same temperature and air/245fa feed ratio, but with the contact time between 26 and 39 seconds. Conversions ranged from 88 to 94.5%. Selectivity for the desired (1234ze) product ranged from 96.2 to 98.5% (17.7 to 20.5% *cis*, 77 to 80.5% *trans*).

[0009] Example 3. 10 ccm of 245fa was bubbled through 3000 ml of 2.7 molar KOH solution at room temperature (about 20°C.). Analysis of the gaseous dry product, using gas chromatography on line, showed 26% conversion, with selectivity for the desired (1234ze) product of 97.9% (23.9% *cis*, 74% *trans*).

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Claims

1. A process for the preparation of *cis/trans* 1,1,1,3-tetrafluoro-2-propene which comprises (a) contacting 1,1,1,3,3-pentafluoropropane with an alkaline solution or with a chromium-based catalyst, and (b) recovering *cis/trans* 1,1,1,3-tetrafluoro-2-propene from the resulting reaction mixture.
2. A process for the preparation of *cis/trans* 1,1,1,3-tetrafluoro-2-propene which comprises (a) contacting 1,1,1,3,3-pentafluoropropane with an aqueous or alcoholic solution of base selected from the group consisting of potassium hydroxide, sodium hydroxide, calcium hydroxide or magnesium hydroxide, and (b) recovering *cis/trans* 1,1,1,3-tetrafluoro-2-propene from the resulting reaction mixture.
3. A process as in Claim 2 wherein step (a) comprises contacting 1,1,1,3,3-pentafluoropropane with an aqueous potassium hydroxide solution.

4. A process for the preparation of cis/trans 1,1,1,3-tetrafluoro-2-propene which comprises (a) contacting 1,1,1,3,3-pentafluoropropane with an oxygen-containing gas in the presence of a fluorid-ed catalyst selected from Cr₂O₃ or Cr/Ni/AlF₃, and 5 (b) recovering cis/trans 1,1,1,3-tetrafluoro-2-pro-pene from the resulting reaction mixture.
5. A process as in Claim 4 wherein the catalyst is flu-
orid-ed Cr₂O₃. 10
6. A process as in Claim 4 wherein the catalyst is flu-
orid-ed Cr/Ni/AlF₃.

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EUROPEAN SEARCH REPORT

Application Number
EP 99 30 5781

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The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
MUNICH		15 February 2000	Janus, S
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			
T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			



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Application Number

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DOCUMENTS CONSIDERED TO BE RELEVANT

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The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
Place of search		Date of completion of the search	Examiner
MUNICH		15 February 2000	Janus, S
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document			

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 99 30 5781

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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15-02-2000

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